

Work Order ID 64237

Tuesday, November 30, 2010 12:59:32 PM



Page 1

Item ID: D4077-2KIV

Accept



Setup Start



Revision ID:

Stop



Item Name: Overhead Panel, RH

Start Date: 11/30/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 12/14/2010 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4077	a								

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x3

Sh

10/12/17

105

0.00



HandThermo

Dry material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 ALEXTRA

Temp: 150°F

Time IN: 6:00 PM 10/12/16

Time OUT: 7:00 AM 10/12/17

x3

Sh

10/12/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Tuesday, November 30, 2010 12:59:32 PM

Page 2

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp. Stamp

0.00

0.00

Memo

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA090 using tool DT9140
Dwg Rev: A
Folio Rev: A

0.00

0.00

Memo

Visually inspect part for proper formation and texture

0.00

0.00

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64237

Tuesday, November 30, 2010 12:59:33 PM

Page 3

Item ID: D4077-2KIV

Accept

Setup Start

Revision ID:

Stop

Item Name: Overhead Panel, RH

Start Date: 11/30/2010 Start Qty: 3.00

Cust Item ID:

Required Date: 12/14/2010 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00



HandThermo

Memo

0.00

Hand-Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

x3

10/12/20

150

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

x3

10/12/20

160

0.00



QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

S 10/12/22

(x3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64237

Tuesday, November 30, 2010 12:59:33 PM

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Item ID: D4077-2K1V

Accept

Setup Start

Revision ID:

Stop

Item Name: Overhead Panel, RH

Start Date: 11/30/2010 Start Qty: 3.00

Cust Item ID:

Required Date: 12/14/2010 Req'd Qty: 3.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPP 64235

0.00

Packaging

11/01/02 (3)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/01/03

11.01.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, November 30, 2010 12:59:32 PM

Work Order ID: 64237



Parent Item: D4077-2KIV



Parent Item Name: Overhead Panel, RH

Start Date: 11/30/2010

Required Date: 12/14/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev. A New Issue 10/11/30 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased		No		100	sf	402.9050	6	18.09045			



6185 KYDEX .080"



Location

Loc Qty

Loc Code

therm

402.905

109703

402.905

18.09045 sg H

Wh
10/12/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

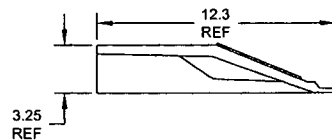
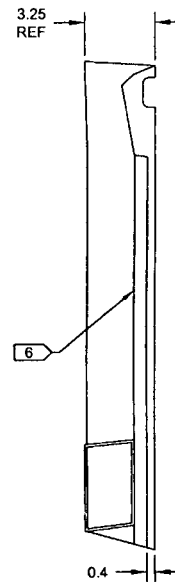
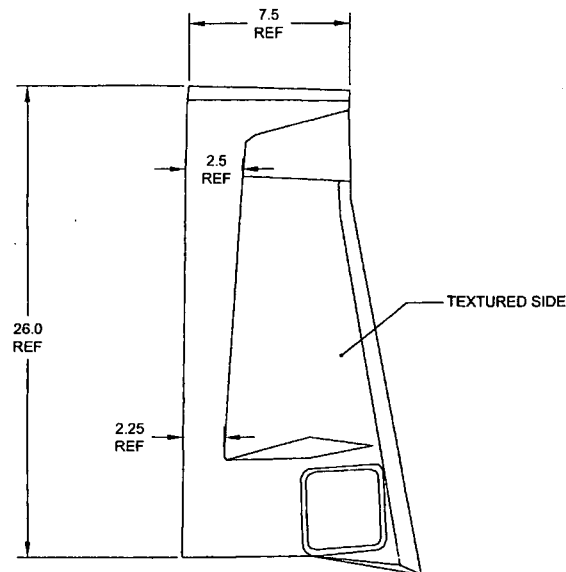
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

64237



D4077-1 OVERHEAD PANEL, LH

RELEASED
2010-11-26

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N (SEE TABLE) PER DART QSI 044 6.4
- 7) WEIGHT: 1.07 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9139 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.045" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D4077-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D4077-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

A NEW ISSUE		SC	10.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	SC	DRAWING NO.	REV. A
MFG. APPR.	SC	D4077	SHEET 1 OF 2
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	OVERHEAD PANEL (BELL 206 A/B)	NTS
DATE	10.10.21	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

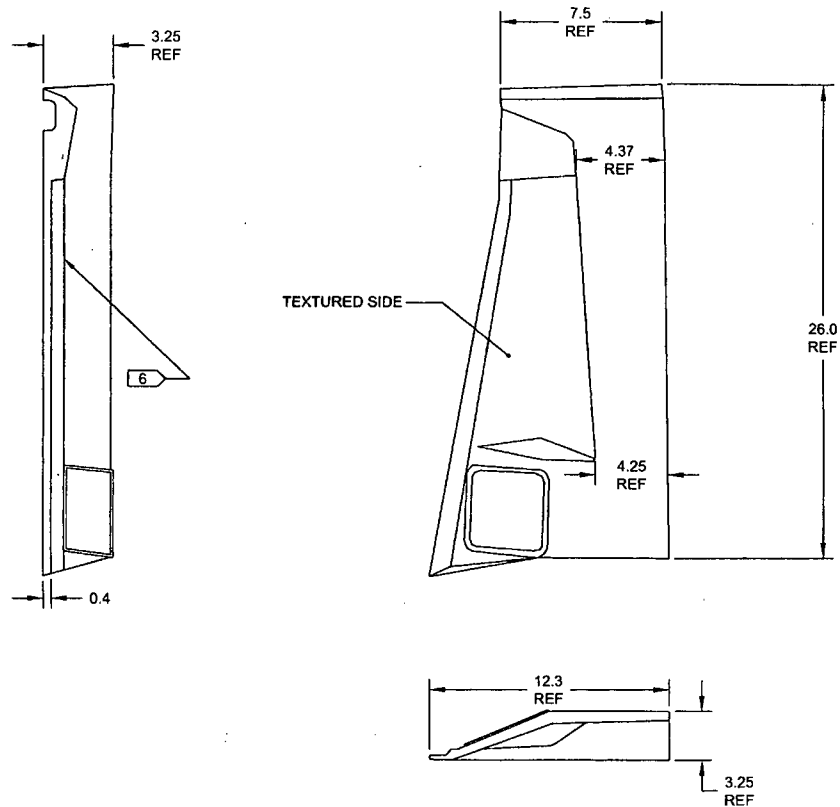
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

64237



D4077-2 OVERHEAD PANEL, RH

RELEASED
R 2010-11-10

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N (SEE TABLE) PER DART QSI 044 6.4
- 7) WEIGHT: 1.03 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9140 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.045" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D4077-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D4077-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	9	D4077	SHEET 2 OF 2
APPROVED	9	TITLE	SCALE
DE APPR.	9	OVERHEAD PANEL (BELL 206 A/B)	NTS
DATE	10.10.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 64237
Description: Airframe Panel R+1	Part Number: D4077-2K10
Inspection Dwg: D4077 Rev: A.	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: W. G.	Date: 10/12/20
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.0"	Ref	26.0"	✓			
7.5"	Ref	7.5"	✓			
12.3"	Ref	12.3"	✓			
3.25"	Ref	3.25"	✓			
0.4"	±.100	0.358"	✓			
0.045"	MIN	0.058"	✓			

Measured by: W. G.	Date: 10/12/20
Audited by: S	Date: 10/12/22
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14